



Date: Thursday, 04/01/2007 8:39:51 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG WELDMENT
Job Number : 29492	
Estimate Number : 12118	
P.O. Number : N/A	Part Number : D3353042
This Issue : 04/01/2007 S.O. No. : N/A	Drawing Number : D3353 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : 16/11/2006 Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 25803	Material : N/A
Written By : 	Due Date : 10/12/2006
Checked & Approved By : _____	Qty:  Um: Each
Comment : est rev A 06.01.26 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D335311	universal joint
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) (3)

pick:

qty	part number	description
1	D3353-11	universal joint

batch

B27330

B29515 → 2

CPL 07.01.05

2.0	D33535	back plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) (3)

pick:

qty	part number	description
1	D3353-5	back plate

batch

B26813 → 2

B29519

CPL 07.01.05

3.0	D335313	tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) (3)

pick:

qty	part number	description
1	D3353-13	tubing

batch

29516

CPL 07.01.05

4.0	D335317	support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) (3)

pick:

qty	part number	description
1	D3353-17	support

batch

B29518

CPL 07.01.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 04/01/2007 8:39:51 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 29492

Part Number: D3353042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33533

right plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description batch
1 D3353-3 right plate B26804

CPL 07-01-05

③

6.0

D33539

STOP PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description batch
1 D3353-9 stop plate ~~B26804~~ B29521

CPL 07-01-10

③

7.0

D33531

left plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description batch
1 D3353-1 left plate B26803

CPL 07-01-05

③

8.0

D33537

front plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description batch
1 D3353-7 front plate B26805 → 2
B29520 ✓

CPL 07-01-05

③

9.0

D335315

lock bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

✓
qty part number description batch
1 D3353-15 lock bracket B29517

CPL 07-01-05

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 04/01/2007 8:39:51 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 29492

Part Number: D3353042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3353

PL 07-01-11

(3)

11.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

07/01/11 (3)

12.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/01/11 (3)

13.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
1-Mask part as per dwg D3353

M18052

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FL/

07/01/22 (3)

14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/22 (3)

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 8770

PL 7/18/09

(3)

16.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/01/24 (3)

Job Completion



u 5701 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/01/05	10.0	When assembling D3353-13 in D3353-17 the part seized and could not remove it	Q51042	Cut D3353-13 to be remove. Scrap part D3353-13 and replace		07/01/05	Q51042	07/01/05

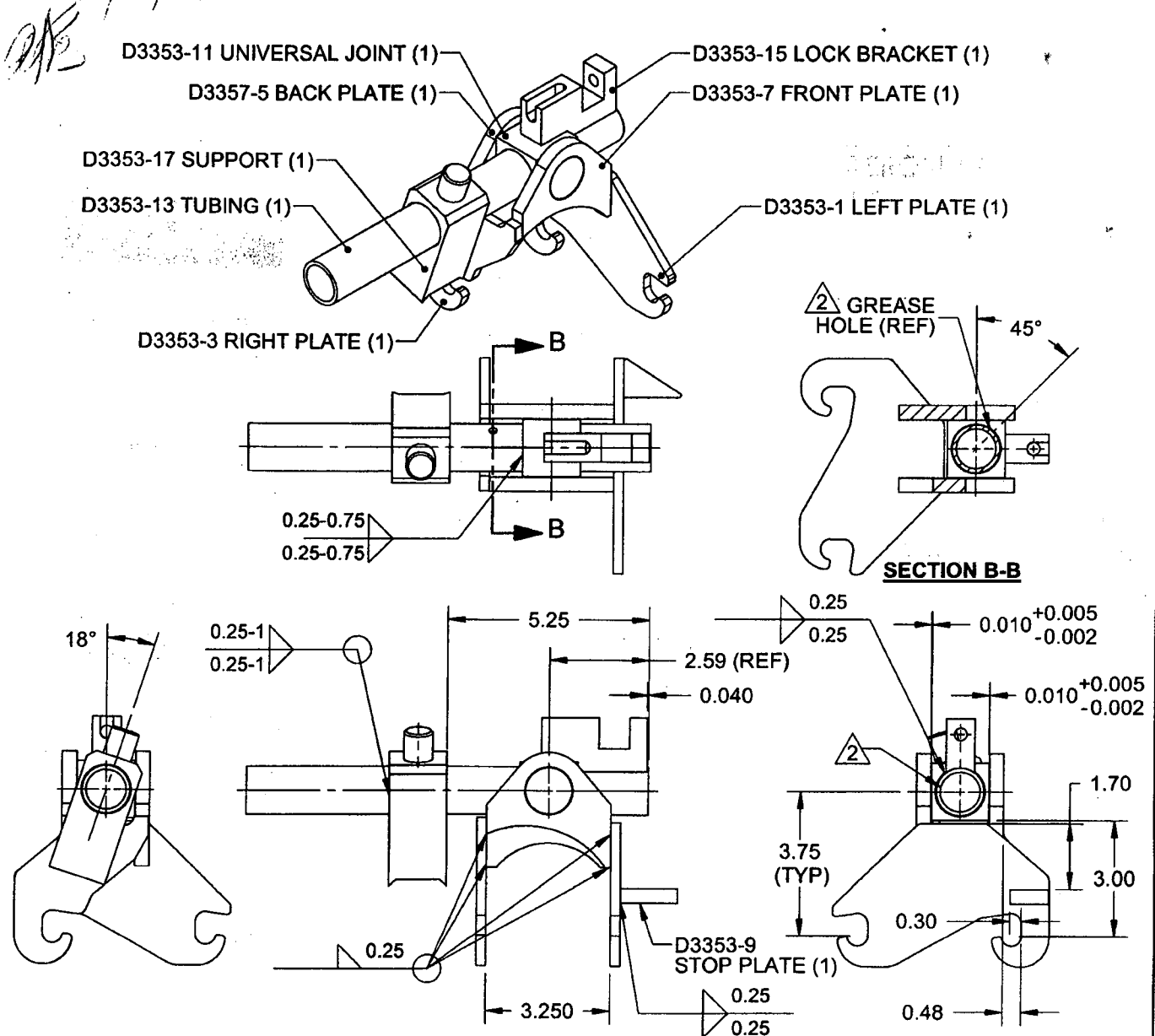
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3353	REV. A SHEET 2 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:4

RELEASED
06/01/59**D3353-042 LUG WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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W/O 29492

C207100112